








# Work Order ID 67453

Monday, March 21, 2011 2:05:21 PM


Page 1


Item ID:	D412-664-203TRN	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Turning Detail					
Start Date:	3/21/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/25/2011	Req'd Qty:	1.00		Customer:	
Reference:						


Approvals:	Process Plan:	<u>11</u>	Date:	<u>11/03/21</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-243	Rev E								

100		MORI SEIKI CNC LATHE LARGE	0.00						
	Mori Seiki	Memo	0.00	<u>aml 11/03/23</u>		<u>1</u>	<u>0</u>		
	Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3- File transition lines smooth.							

110		QC1- Inspect dimensions to dimension sheet	0.00	<u>aml 11/03/23</u>		<u>1</u>	<u>0</u>		
	QC	Memo	0.00						
	Quality Control								

120		MORI SEIKI CNC LATHE LARGE	0.00	<u>aml 11/03/24</u>		<u>1</u>	<u>0</u>		
	Mori Seiki	Memo	0.00						
	Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA166 2- File transition lines smooth. 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-664-203TRW PAR #: \_\_\_\_\_ Fault Category: ex tubes NCR: Yes No DQA: \_\_\_\_\_ Date: 11/03/25  
 Resolution: Accepted Disposition: use as is QA: N/C Closed: OK Date: 11/03/29

NCR: <u>67453</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.03.24	1W	Length is 124.250 AFTER MACHINING R.C. process	CP 11.03.24 QSI/042	ACCEPTABLE. <del>NO</del> TRIM CUFF <del>IF</del> REQ'D AFTER BENDING	<u>me</u> 11/03/23	Is. A 11/03/24	CP 11.03.24 QSI/042	<u>me</u> 11/03/25
			<u>me</u> 11/03/24	Reel tag tube for bending & with NCR info	<u>me</u> 11-3-23	<u>me</u> 11/03-29	<u>me</u> 11/03/24	<u>me</u> 11/03/25
			<u>me</u> 11/03/24	Trim cuff <u>NOT</u> req. as per dim sheet on B67438	<u>me</u> 11-3-29	<u>me</u> 11/03-29 W/O FAI was good.	<u>me</u> 11/03/24	<u>me</u> 11/03-29

NOTE: Date & initial all entries

**Work Order ID 67453**

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Page 2

Item ID: D412-664-203TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 3/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

ml 11/03/24

1 0

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 11/03/24

1 0

150



HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

Memo

0.00

SAD  
11-03-24

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

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Revision ID:

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Start Date: 3/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspct Part Finish

0.00

11-3-24

QC

Memo

0.00

Quality Control

170



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: 46

11-3-24

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

MF

11-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 21, 2011 2:05:26 PM

Page 1

Work Order ID: 67453

Parent Item: D412-664-203TRN

Parent Item Name: Crosstube Turning Detail




Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:cec  
IPP Rev B 08.04.02 Removed polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129 		Manufactured	No			120	Each	6.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

LG

6

38342

2

53594

4

B34691 X 1

amr 11/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	67452
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b>	D412-664-243
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> E		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.686	—		Micro CML-04	
	2.748	+0.005/-0.000	2.753	—		"	
	2.884	+0.005/-0.000	2.887	—		"	
	3.019	+0.005/-0.000	3.021	—		Micro CML-05	
	3.163	+0.005/-0.000	3.167	—		"	
	3.308	+0.005/-0.000	3.313	—		"	
	3.429	+0.005/-0.000	3.434	—		"	
	2.990	+0.005/-0.000	2.995	—			
	2.618	+0.005/-0.000	2.623	—			
	0.200	+/-0.010	.208	—		Vern ML-7	
	R0.063	+/-0.010	R.063	—		Rad-gage	
	R0.500	+/-0.010	R.500	—		"	
	4.971	+/-0.030	5.000	—		Vern ML-7	
SIDE B	2.684	+0.005/-0.000	2.689	—		Micro CML-05	
	2.748	+0.005/-0.000	2.753	—		"	
	2.884	+0.005/-0.000	2.889	—		"	
	3.019	+0.005/-0.000	3.024	—		Micro CML-05	
	3.163	+0.005/-0.000	3.168	—		"	
	3.308	+0.005/-0.000	3.313	—		"	
	3.429	+0.005/-0.000	3.433	—		"	
	2.990	+0.005/-0.000	2.995	—			
	2.618	+0.005/-0.000	2.623	—			
	0.200	+/-0.010	.208	—		Vern ML-7	
	R0.063	+/-0.010	R.063	—		Rad-gage	
	R0.500	+/-0.010	R.500	—		"	
	4.971	+/-0.030	5.000	—			
	124.100	+/-0.020	124.250	NO	✓	M-tape ML-2	

<b>Measured by:</b>	me
<b>Date:</b>	11/03/23

<b>Audited by:</b>	B.A
<b>Date:</b>	11/03/24

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	
D	10.02.02	Dimension 124.100 was 124.09	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 47.0 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67453  
281103-21

RELEASED  
2009-10-29  
WNP

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 1 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	JH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

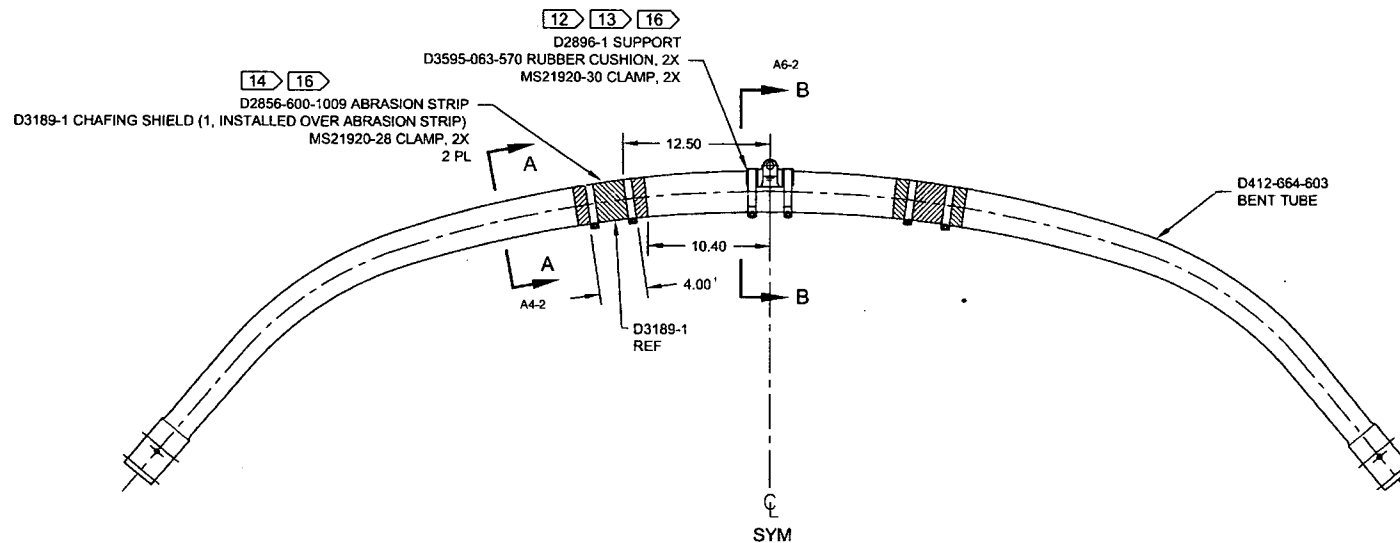
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

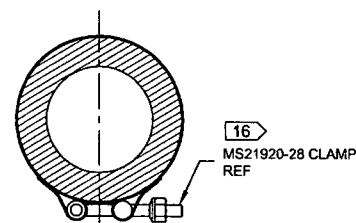
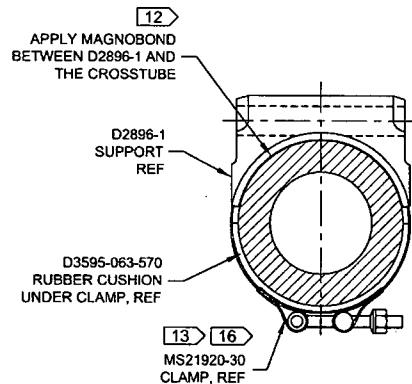
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D212-664-243**  
**ASSEMBLY DETAIL**



*W/O 67453*

**RELEASED**  
2009-10-29  
*MM*

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>PS</i>	D412-664-243	SHEET 2 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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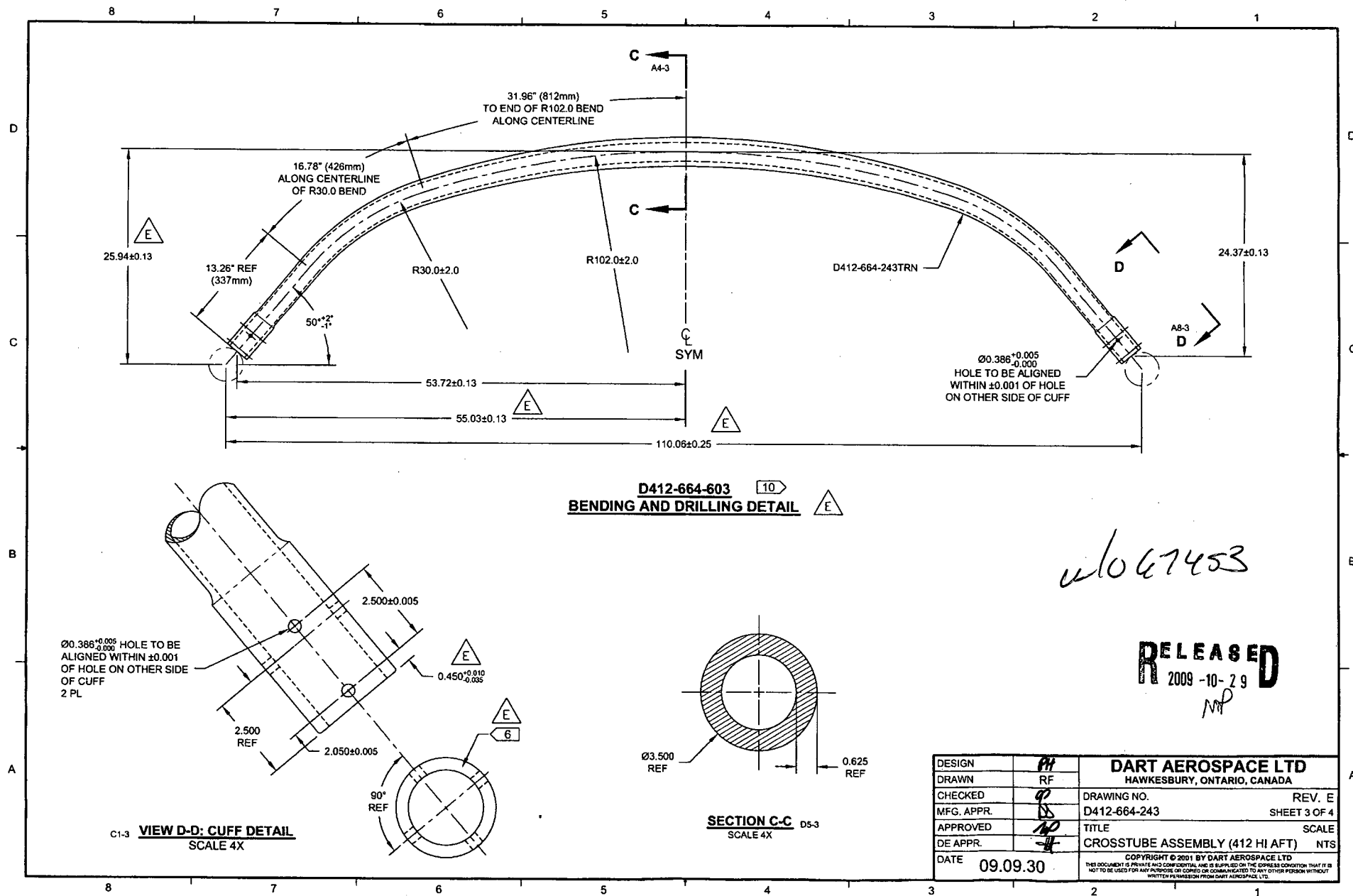
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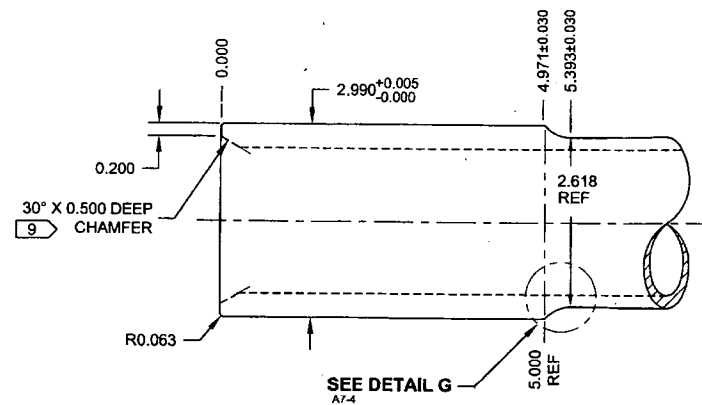
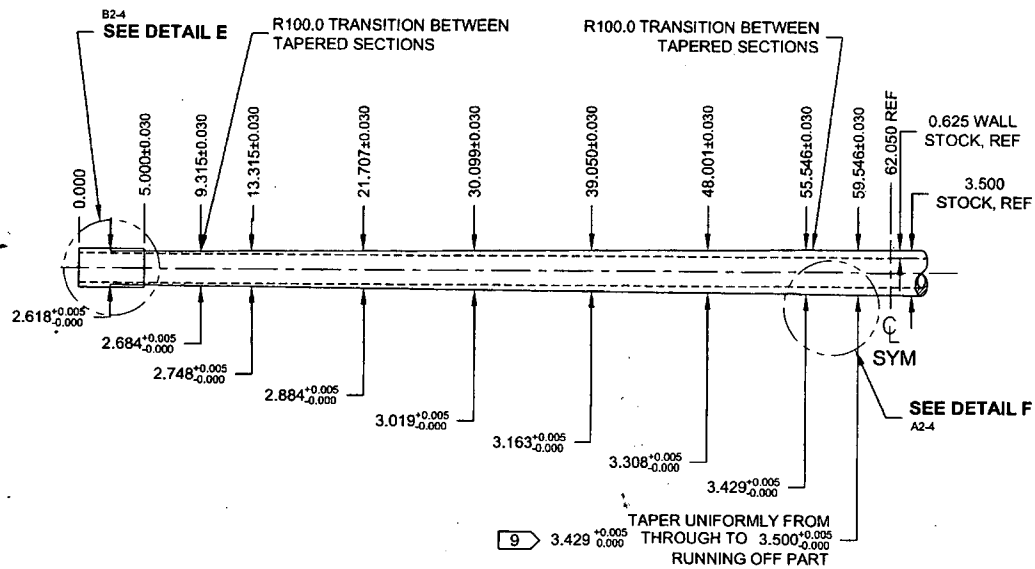
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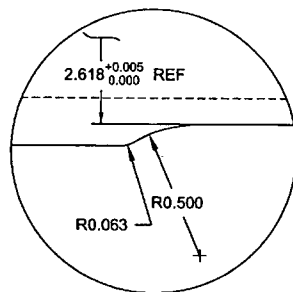
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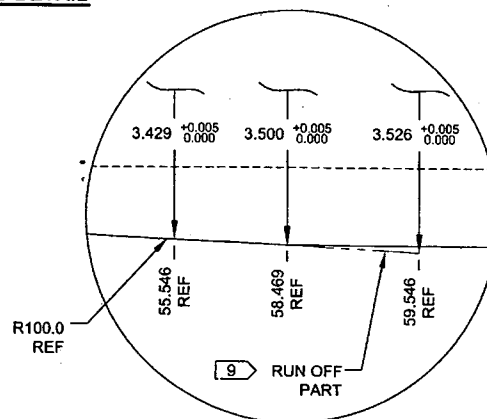


DETAIL E:  
CROSSTUBE CUFF D8-4  
SCALE 5X

**D412-664-243TRN**  
**TURNING DETAIL** E



DETAIL G:  
CUFF TRANSITION C2-4  
SCALE 10X



DETAIL F:  
TAPER RUN-OFF C4-4  
NOT TO SCALE

260 67453

**RELEASED**  
2009-10-29  
NTP

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. E
MFG. APPR.	18	D412-664-243	SHEET 4 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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